

Split

Dart Aerospace Ltd.

Wednesday 10/14/05 12:00 PM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BEARING ASSEMBLY		
Job Number	: 25225 -1			Part Number	: D3121241		
Estimate Number	: 10716			Drawing Number	: D3121 REV C2		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 12/14/2005	S.O. No.	: N/A	Drawing Revision	: C2		
Prsh't Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 12/21/2005		
Previous Run	: 24777			Qty:	-20 Um: Each		
Written By	: See Comment below						
Checked & Approved By	: See Comment below						
Cust. Prod.	: Est Rev:A 04.02.18 New issue KJ/D/S						

(Product)

ber:



#:	Machine Or Operation:	Description :	
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"	
	Comment: Qty.: 0.0431 f(s)/Unit Total: 0.8610 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500) Identify as D3121-25 Batch: 12124		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
	Comment: HARDINGE CNC LATHE SMALL		
	1-Turn D3121-25 Cap as per Follo FA387	→ M8 osh12121	79
	2-Deburr	→ M8 osh12121	79
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	M8 osh12121	79
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK	Op osh12127	79
5.0	D312123	Bearing	
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: Qty Part Number Description Batch		
	1 D3121-23 Bearing B2445SE (10x) B25340 (40x) DL 066469 50		

Wednesday 12/14/2005 3:56:56 PM

Jim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 25225

Part Number: D3121241

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

DL 06/01/09 50

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 401

DL 06/01/09

49

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sur 06/01/10 49

DP 06/01/10

49

Job Completion



**DART**

DESIGN	DRAWN BY
CHECKED	APPROVED
DATE 04.02.17	

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

REV. C

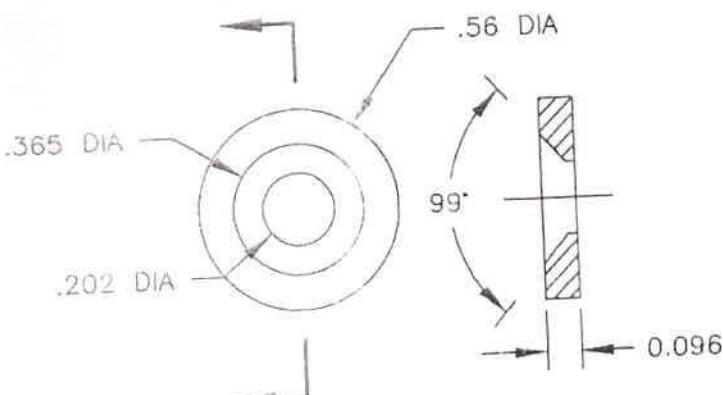
DRAWING NO.  
D3121

SHEET 10 OF 10

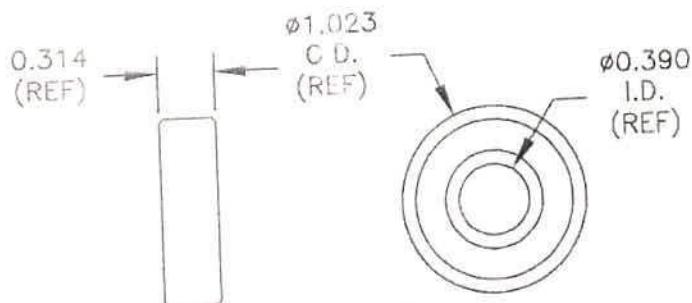
SCALE

TITLE  
BRACKET ASSEMBLY

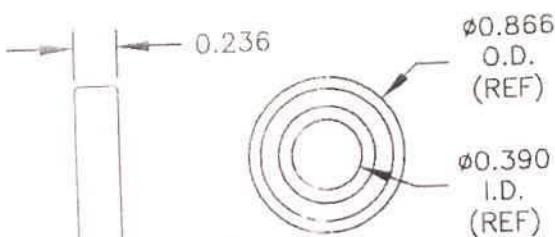
1:1

**D3121-17 WASHER (SCALE 2:1)**

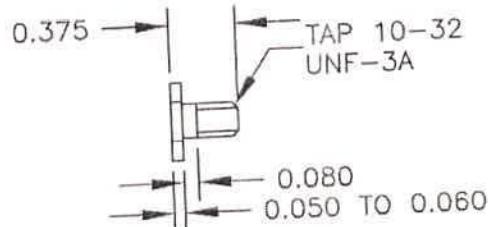
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

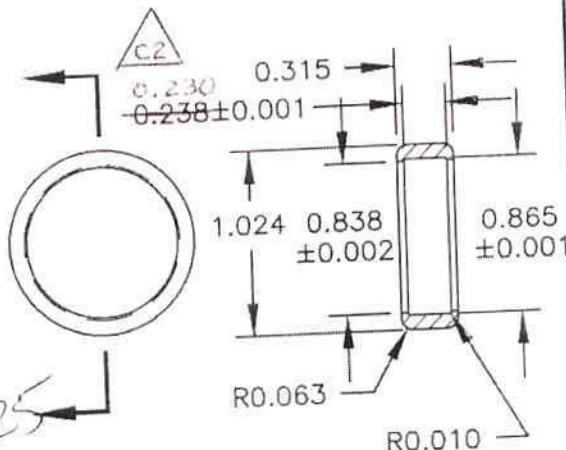
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

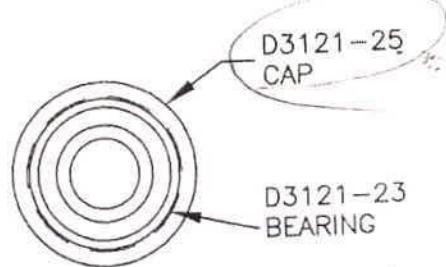
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



RELEASED  
04-03-01 C

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-05	6	I bearing scrapp. bearing has dent from pressing and doesn't roll good.		Scrap & destroy	2 06-01-05	2 06-01-05		2 06-01-05

NOTE: Date & initial all entries